

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024849**Date Inspected:** 04-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Shi Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Yard

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SA3124-001-001 and 005 located on bottom plate connected SA3124 at panel point 122 to 122.5 FL3 side of OBG Segment 13B/CW. ZPMC Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

FCAW welding of weld joint SEG3015H-353 located on vertical plate RS stiffener at panel point 123 CW side of OBG Segment 13CW. ZPMC Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3015-009 located on Deck Panel to Edge Plate at panel point 124 to 123.5 CB Side of OBG Segment 13CW. ZPMC Welder is identified as 068596. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

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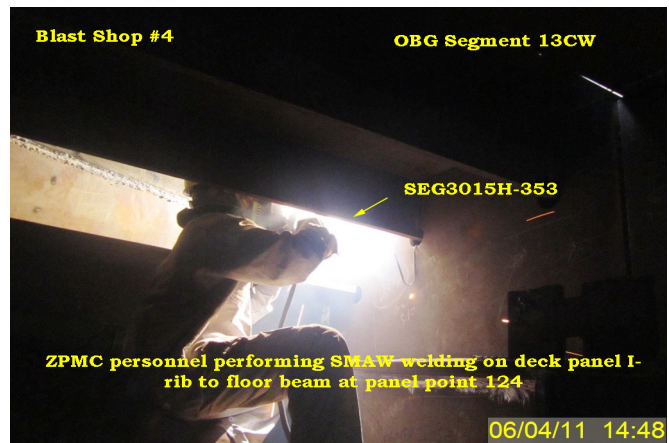
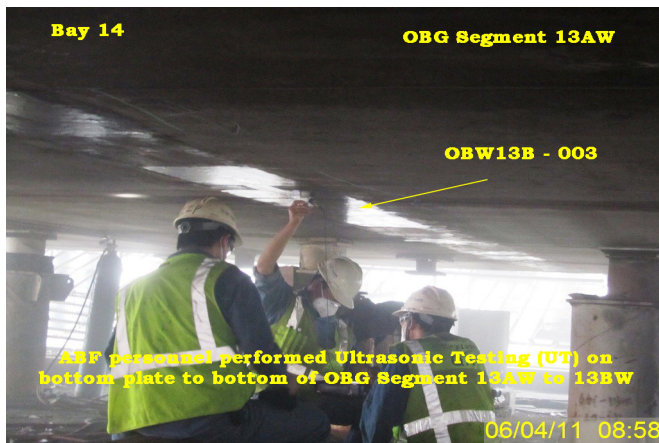
SMAW welding of weld joint SEG3015U-002 located on Deck Panel to Vertical Plate at panel point 122.5 to 123.5 CW Side of OBG Segment 13CW. ZPMC Welders are identified as 068097, 066156 and 067947. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3014S-076 located on K-plate RS stiffener at panel point 120.5 CW Side of OBG Segment 13BW. ZPMC Welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3015B-167 located on Deck Panel to Deck Panel Diaphragm at panel point 124.5 to 124 CW Side of OBG Segment 13CW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

This QA inspector observed ABF personnel performed Ultrasonic Testing (UT) on bottom plate to bottom of OBG Segment 13AW to 13BW. The panel point is identified as PP120 to 120.5. The weld number is identified as OBW13B-003. See the attached picture.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

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Reviewed By: Patel,Hiranch

QA Reviewer